

Work Order ID 60027



Page 1

Tuesday, June 22, 2010 3:25:50 PM

Item ID: D4047-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *11*

Date: *10-6-24* Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4047

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D4047
2- Deburr and remove identification markings

SAD 10-06-24

(2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SAD 10-06-24

(2)

120

Identify as per dwg & Stock Location: *W/O*

0.00



Packaging

Memo

0.00

Packaging

SAD 10-06-24

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

C210/0125

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Picklist Print

Tuesday, June 22, 2010 3:25:54 PM

Page 1

Work Order ID: 60027

Parent Item: D4047-1

Parent Item Name: Rib



Start Date: 6/22/2010

Start Qty: 2.00

Required Date: 7/30/2010

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10/01/06 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049

Purchased

No

100

f

446.7945

5.333

11.22737



304 SQ Tube .75x.75x.049W



SAD 10-06-24

Location

Loc Qty

Loc Code

MAT

146.7944919

113763

0

114323

28.3020789

114677

14.34201

114835

104.150403

MAT017

3.68448E-05

114298

3.6845E-05

WA

300

114992

300

11.2273

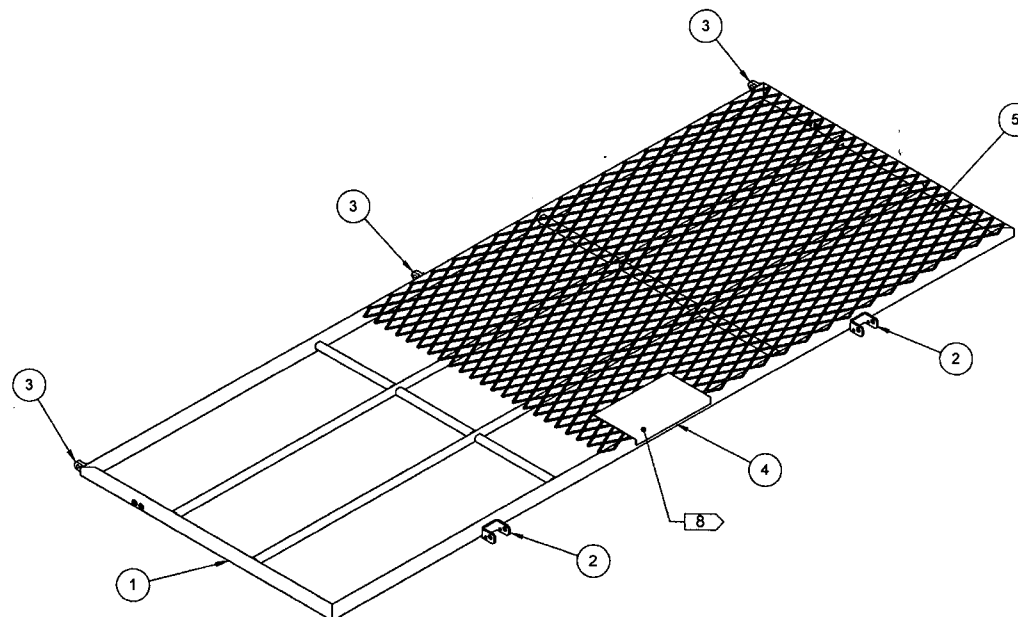
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NOTE: Date & initial all entries



D4047-041 SHORT BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE PER DART QSI 005 4.4

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60027

BS 10-6-22

RELEASED
2010-02-16
NP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4047

TITLE
SHORT BASKET LID ASSY

SCALE
NTS

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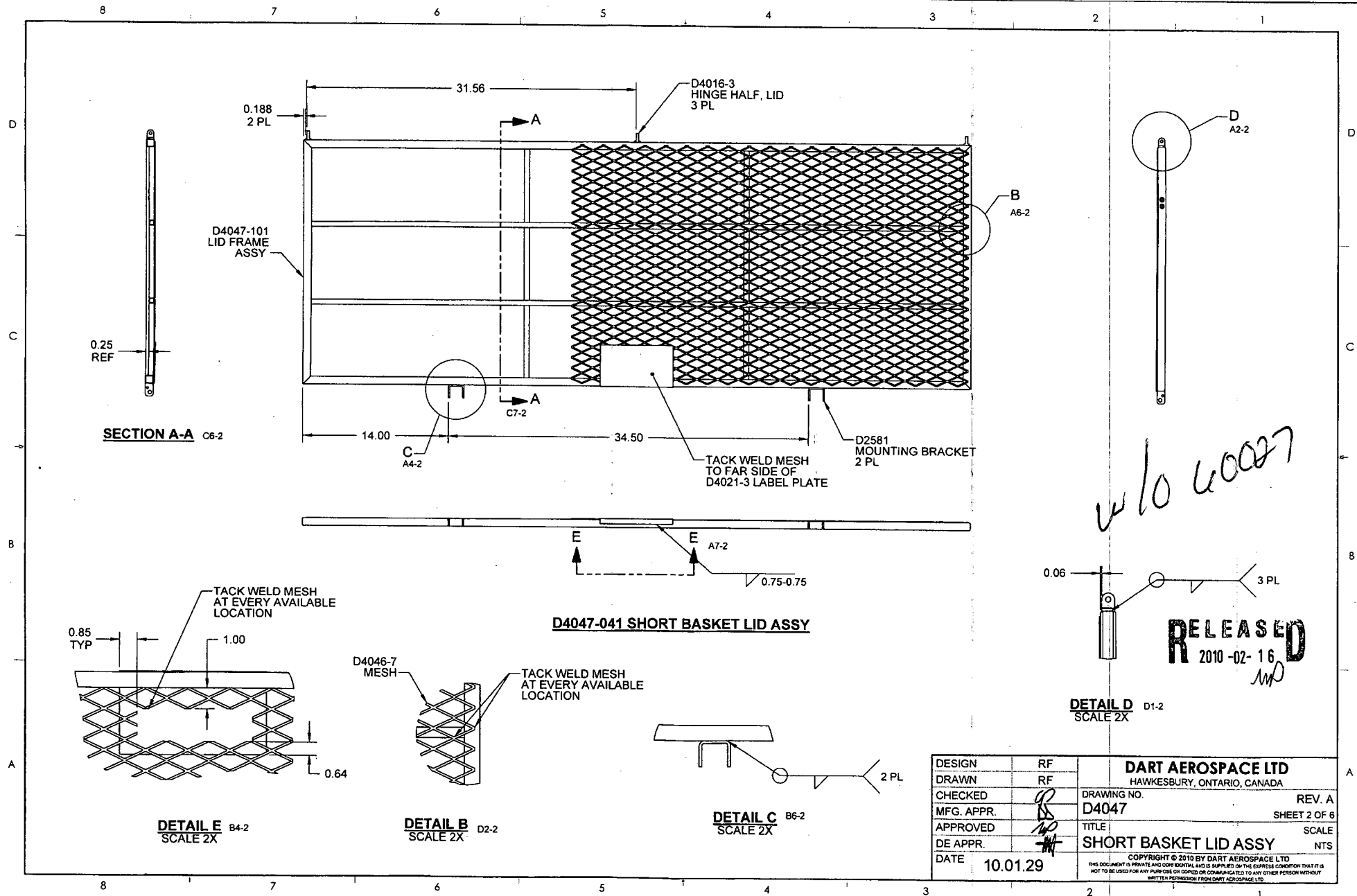
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NOTE: Date & initial all entries



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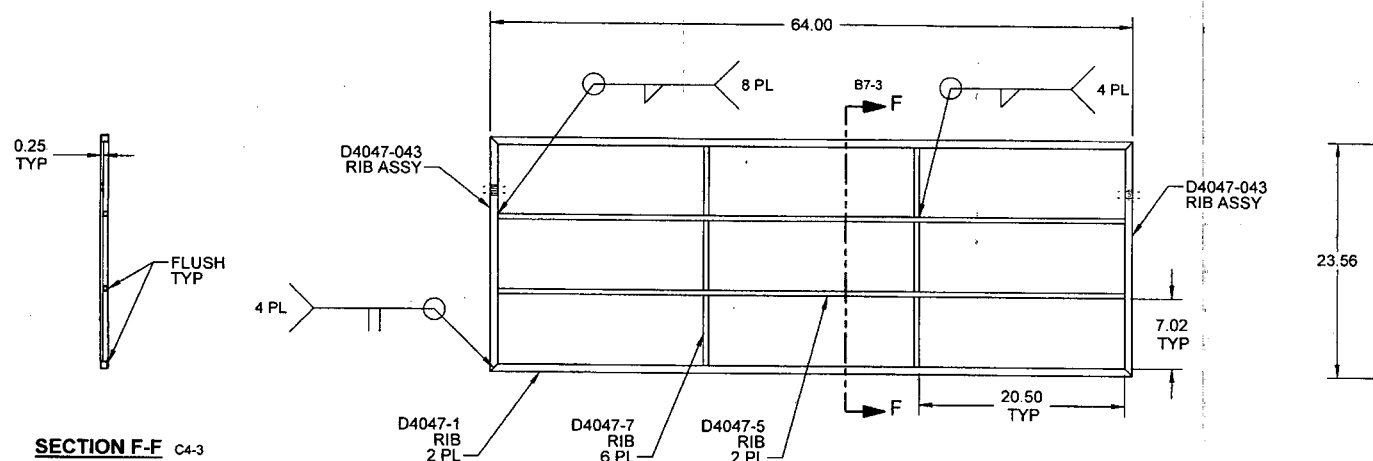
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ITEM	QTY	P/N	DESCRIPTION
	X	D4047-101	LID FRAME ASSY
1	2	D4047-043	RIB ASSEMBLY
2	2	D4047-1	RIB
3	2	D4047-5	RIB
4	6	D4047-7	RIB



D4047-101 LID FRAME ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 10.33 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4047	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY	NTS
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2010-02-16
[Signature]

w/o 60027

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

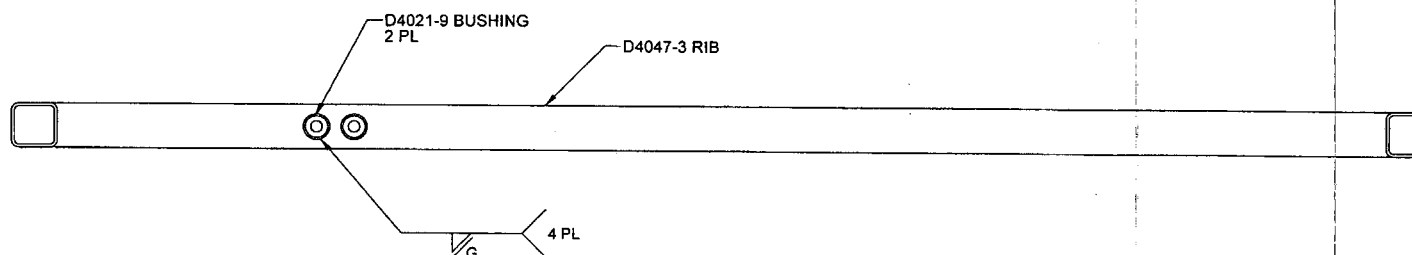
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

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MFG. APPR.	<i>[Signature]</i>	D4047	SHEET 4 OF 6
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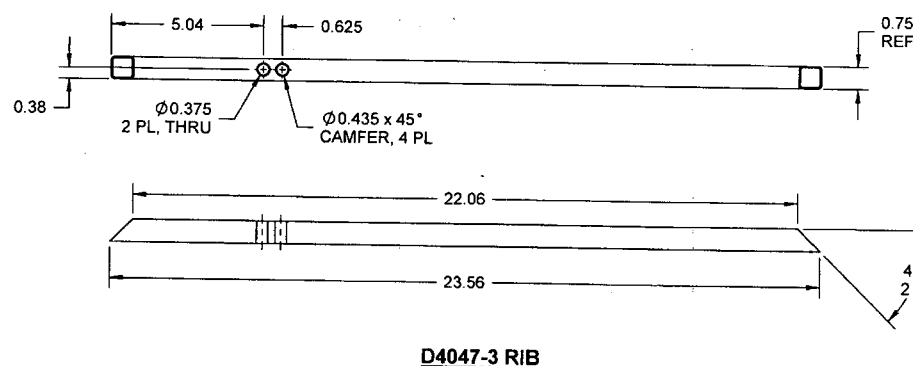
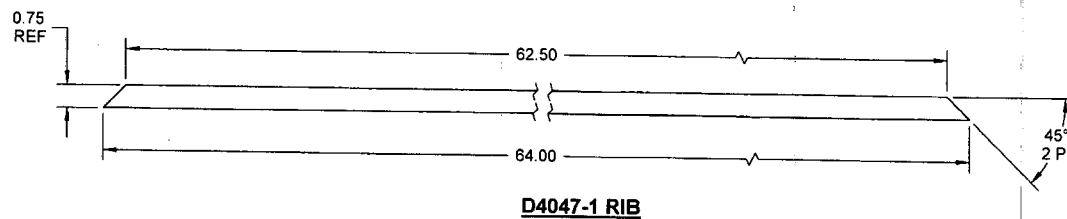
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs
D4047-3: 0.84 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4047	SHEET 5 OF 6
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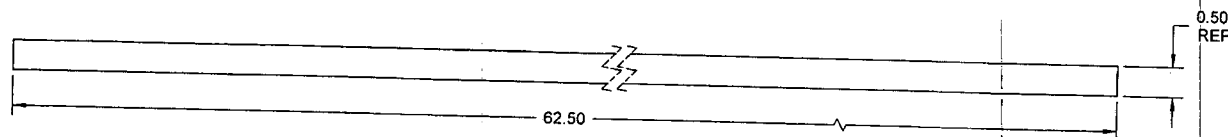
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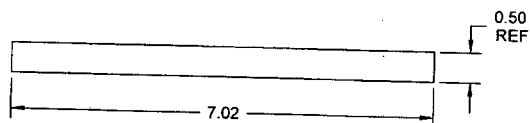
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NOTE: Date & initial all entries



D4047-5 RIB



D4047-7 RIB

WLB 60027

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2010-02-16
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs
D4047-7: 0.16 lbs

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